

Date: Thursday, 12/02/2009 12:08:18 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 350/212/130 BASKET LID		
Job Number	: 45771B			Part Number	: D2512		
Estimate Number	: 10193			Drawing Number	: D2512 REV E		
P.O. Number	:			Project Number	: N/A		
This Issue	: 12/02/2009 S.O. No. :			Drawing Revision	: E		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : LARGE FAB ASSY			Due Date	: 25/02/2009 Qty: 1 Um: Each		
Previous Run	: 44873B						
Written By	:						
Checked & Approved By	:						
Comment	: Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/ RF						
	Est Rev:N 06.04.05 Added level21 EC						
	Est Rev:O 08-08-29 revE as per dwg DD verified by:EC						
	Est Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W	
✓			
		Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)	
		Pick: 3/4"x3/4" 304/316 SS tube .065" wall	
		Batch: <u>7m110-561</u>	SAD 09-02-17 ①
✓ 2.0	D31663	Basket Hoop	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick: Qty Part Number Description Batch	
		1 D3166-3 Basket Hoop <u>345780</u>	SAD 09-02-17 ①
3.0	D2506	Label Plate	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick: Qty Part Number Description Batch	
		1 D2506 Label Plate <u>39457 → 1x</u>	<u>SL 09/02/07</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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4.0 D23271 Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
2 D2327-1	Bushing	<i>340390 → 2x</i>

SJ 09/02/17

5.0 D22321 Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
2 D2232-1	Hinge plate	<i>339454 → 2x</i>

SJ 09/02/17

6.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
2 D2581	Mounting Bracket	<i>343800 → 2x</i>

SJ 09/02/17

7.0 M304EX07516F Expanded Metal Flat SS



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number	Description	Batch
18 sf	M304EX0.75-16F Expanded Metal	<i>M10861</i>

SJ 09/02/18

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

*SJ 09/02/18
SAN 09/02/18
1x
D202-12*

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Seq. #: Machine Or Operation:

Description :

9.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-02-18

10.0 QC6

DIMENSIONAL CHECK



J 09-02-19 ①



Comment: DIMENSIONAL CHECK

11.0 POWDER COATING

POWDER COATING



PRESSURE WASH



BR 09-02-19

Comment: POWDER COATING

✓ 1- Plug holes in D2581 and in D2327-1 bushing prior to powder coating

✓ 2- Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME: 8:45 am

OVEN TEMPERATURE: 400°F

FINISH TIME: 9:15 am

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

12.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



M109996 HJ 09-02-18

X1 09/02/19

Comment: HAND FINISHING RESOURCE #1

Spray paint: m 110211 Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4.1(WW) Batch: M110454

09/02/19

13.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PD RX 09/02/19

14.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: APP 44771

09/02/19

W/O:		WORK ORDER CHANGES					
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Description :

15.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/19 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-02-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

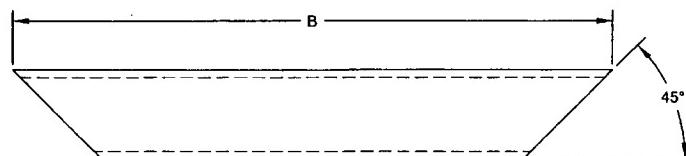
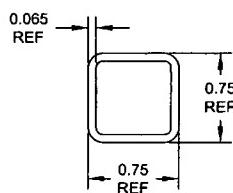
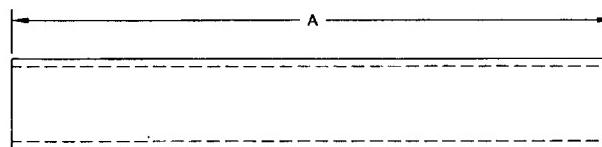
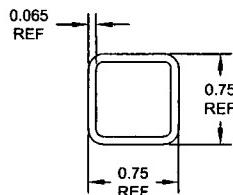
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8 7 6 5 4 3 2 1

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	_____	25.50	RIB
D2512-3	2	_____	95.30	RIB
D2512-5	6	30.84	_____	RIB
D2512-7	3	30.63	_____	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET



E

- D2512-1/-3/-5/-7 NOTES:**
- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: N/A
 - 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- [Handwritten signature]*

RELEASED
(08-08-21/17)

REV.	DESCRIPTION	BY	DATE
E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERED TO "B" FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS. INCOR DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE OR DISCLOSED TO OTHER PERSONS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

3 2 1

1

